

Date: Tuesday, 11/21/2006 2:40:01 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L AFT X-TUBE
Job Number	: 29632		
Estimate Number	: 10973		
P.O. Number	: N/A	Part Number	: D206667203
This Issue	: 11/21/2006 S.O. No. : N/A	Drawing Number	: D206-667-243 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: B
Previous Run	: 29631	Material	: N/A
Written By	: <u>HA</u>	Due Date	: 12/20/2006 Qty: 1 Um: Each
Checked & Approved By	: <u>HA 061121</u>		
Comment	: Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG002

06.11.28 KJ.

2.0

D6004115

Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
-----	-------------	-------------	-------

1	D6004-115	Crosstube	B25664
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Check OD = 2.500"; ID = 1.800"

MS 06/11/25

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA089

2-Turn first side as per Folio FA089

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

MS 06/11/25

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

MS 06/11/25

NOTE: This form is Quality Assurance approved OAC/CR/OT/TE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

Date & initial all entries

Date: Tuesday, 11/21/2006 2:40:02 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 29632

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA089

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

3-Polish entire outside surface of crosstube

JI 06-12-11/12 ①

4-Remove sand and plugs

5-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243

Inside of Cuff(Donot engrave on outside of tube)

MS 06/11/26 1

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

MS 06/11/26 1

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 06.12.08 1

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DP/5D 6/12/12 ①

9.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT

DP7-1-24

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

07-01-26 ①

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.

07-01-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 2:40:02 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 29632

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243  
Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

PT  
07-01-27

1/11 07-01-29

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

1/11 07-01-29

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JOA 02-05 (1)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JOA 02-05 (1)

15.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 30416

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C 207102106 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 2:40:02 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 29632

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

EO 7/2/16 (1)

17.0

QC8  
005

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

07-2-16

18.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number

Description Batch

2 D2873-045

Nut Plate

28695

ET 07-03-02

\*

19.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number

Description Batch

2 D2873-043

Nut Plate

28387

ET 07-03-02

\*

20.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick:

Qty Part number

Description Batch

14 MS20601AD4W10 Rivet

1102455

ET 07-03-02

\*

21.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

ET 07-03-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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## Process Sheet

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Drawing Name: 206L AFT X-TUBE

Job Number: 29632

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes *N/A*

2-Prime inside and outside crosstube as per QSI 005 4.2

3-Paint outside crosstube with White Imron as per QSI 005 4.2

*ml 07 02 27 (1)*

*ml 07 02 28 (1)*

23.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

*RT 07 -03 -02*

24.0

D2856400

Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total : 1.3525 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 7.73") Abrasion Strip

*27285*

*RT 07 -03 -02*

25.0

D28921

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

-2 D2892-1 Support

*27970*

*RT 07 -03 -02*

26.0

MS2192022

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22

Clamp

*102389*

*RT 07 -03 -02*

27.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8580. .Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

*RT 07 -03 -02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 2:40:03 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 29632

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07-03-09*

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

*mf. 07-03-09*

30.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: *m101340* ✓

*mf 07-03-09*

31.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: *m100564* ✓

*mf 07-03-09*

32.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt *m103389* ✓

*mf. 07-03-09*

33.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-32A

Bolt *m103287* ✓

*mf. 07-03-09*

34.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

*mf. 07-03-09*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 11/21/2006 2:40:03 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 29632

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

18 AN960JD516 Washer M102929

35.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

PACKAGING RESOURCE #1

36.0

PACKAGING 1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location:

PPP Rev: C

37.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07.03.14

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 29632
<b>Description:</b> Crosstube Assembly	<b>Part Number:</b> D206-667-243
<b>Inspection Dwg:</b> D206-667-243 <b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

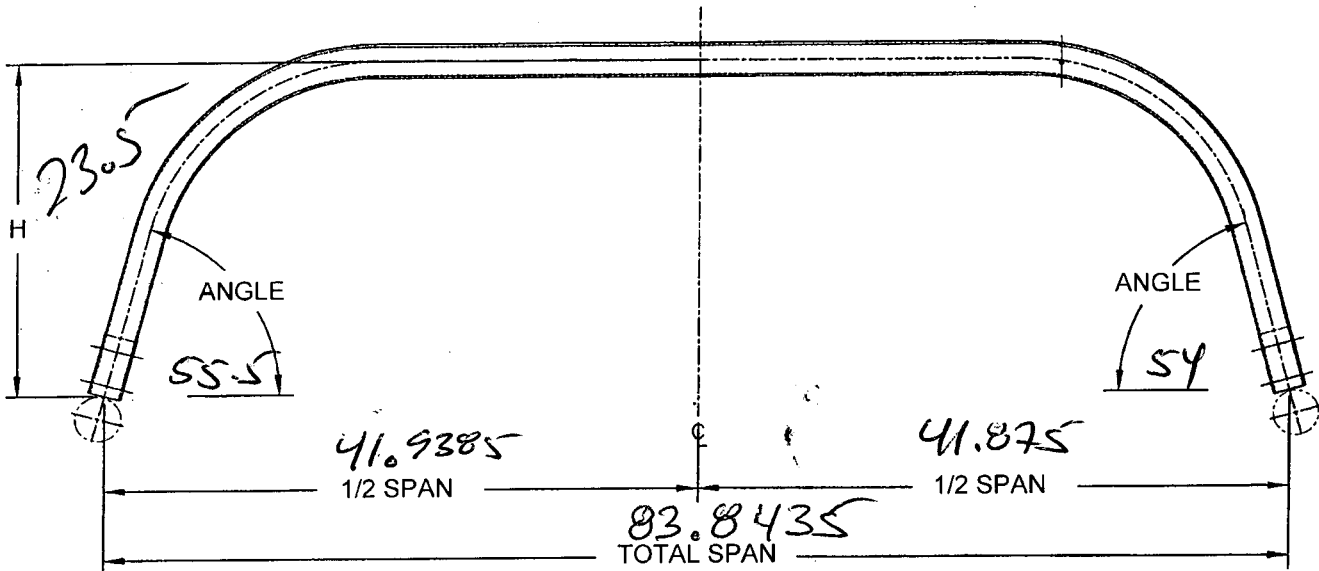
☒ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.495	✓			
	2.018	+0.005/-0.000	2.023	✓			
	2.079	+0.005/-0.000	2.083	✓			
	2.145	+0.005/-0.000	2.149	✓			
	2.209	+0.005/-0.000	2.214	✓			
	2.287	+0.005/-0.000	2.292	✓			
	2.363	+0.005/-0.000	2.367	✓			
	2.433	+0.005/-0.000	2.437	✓			
	0.200	+/-0.010	.200	✓			
	0.500 x 30°	+/-0.010	.500	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓			
	4.438	+/-0.030	4.440	✓			
SIDE B	104.91	+/-0.020	104.91	✓			
	2.490	+0.005/-0.000	2.495	✓			
	2.018	+0.005/-0.000	2.023	✓			
	2.079	+0.005/-0.000	2.084	✓			
	2.145	+0.005/-0.000	2.149	✓			
	2.209	+0.005/-0.000	2.214	✓			
	2.287	+0.005/-0.000	2.292	✓			
	2.363	+0.005/-0.000	2.367	✓			
	2.433	+0.005/-0.000	2.438	✓			
	0.200	+/-0.010	.200	✓			
	0.500 x 30°	+/-0.010	.500	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓			
	4.438	+/-0.030	4.440	✓			

<b>Measured by:</b> MB	<b>Audited by:</b> SA	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 06/11/26	<b>Date:</b> 06.12.08	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue (P/O D206-667-203)	KJ/JLM	

## Crosstube Bend Dimension Sheet



Perfect Fit

PART NUMBER: D206-667-203

BATCH NUMBER: 29632

DRAWING: D206-667-243 REVISION: B

H: 23.52

1/2 SPAN: 41.92

TOTAL SPAN: 83.84

ANGLE: 54°

QC 15: [Signature]

DATE: 07-01-26

QTY: 1





DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED # DS	APPROVED # DS	DRAWING NO. D206-667-243	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED  
05-07-26

UNDER REVIEW

06-08-10 RH  
12-draw detail F  
OK  
PH 06-11-21

Qty	Part Number	Description
X	D206-667-243	CROSSTUBE ASSEMBLY
1	D6004-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2892-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-22	CLAMP

#### GENERAL NOTES:

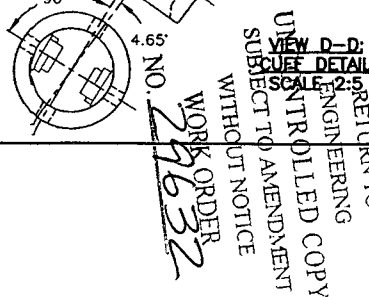
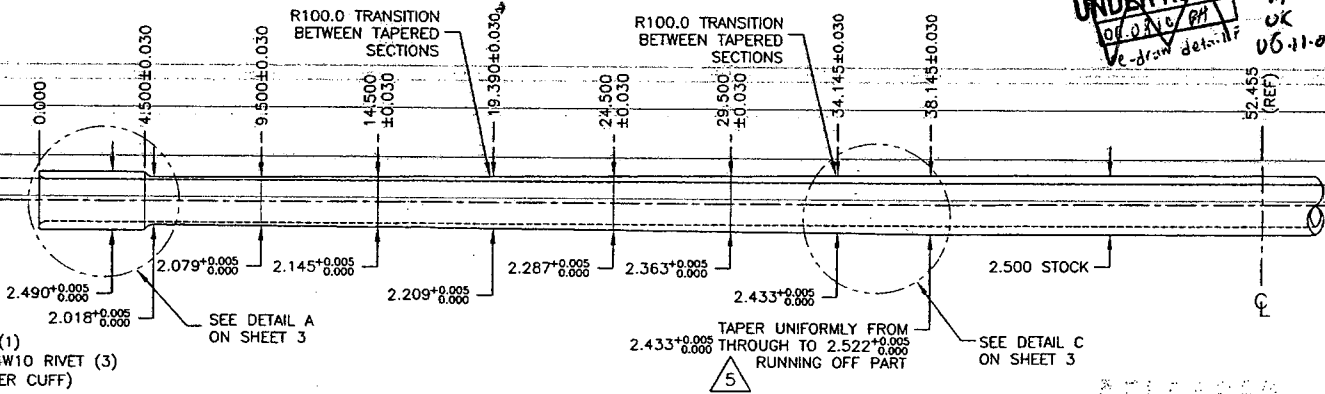
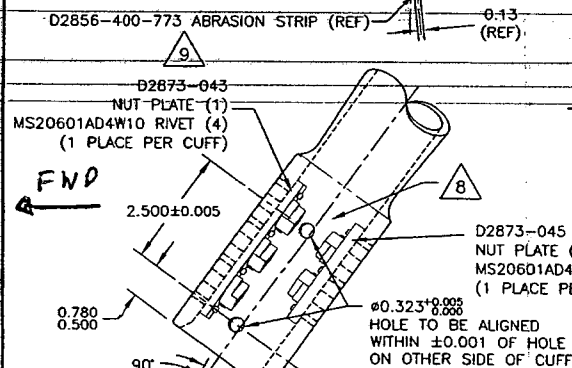
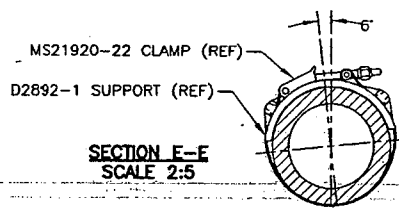
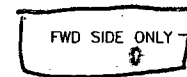
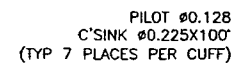
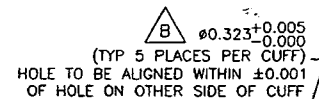
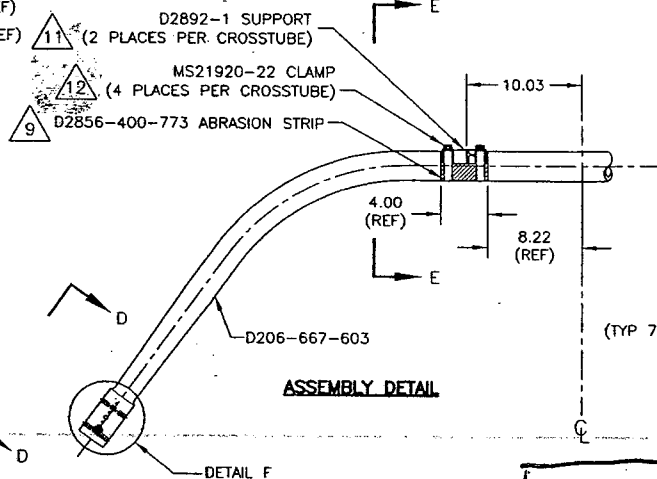
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115  
FINISHED LENGTH =  $104.91 \pm 0.020$
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005.4.2  
PAINT OUTSIDE PER DART QSI 005.4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13" (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.


SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29632

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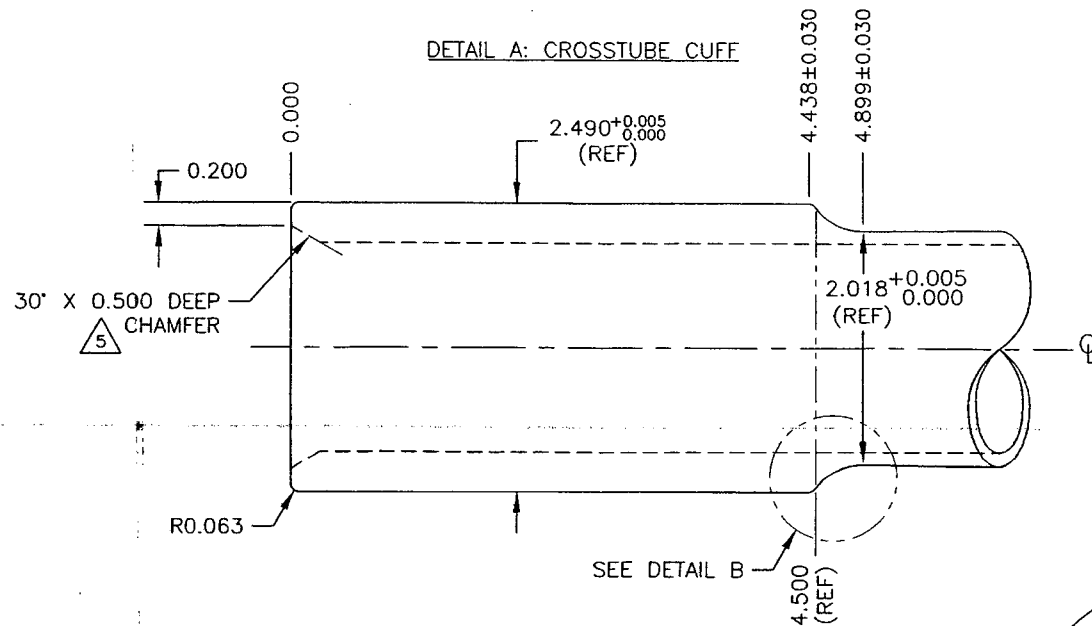
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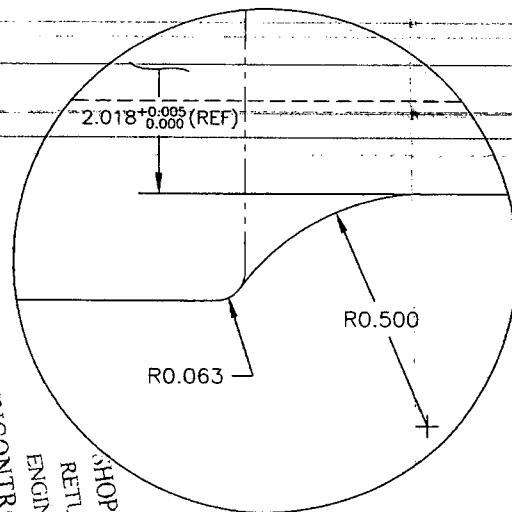


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	PH	PH		
	CHECKED	APPROVED		DRAWING NO.
	# DS	# DS		D206-667-243
	DATE	TITLE	REV. B	
	05.07.26	CROSSTUBE ASS'Y (206L HIGH AFT)	SHEET 2 OF 3	
			SCALE	
			1:10	

# DETAIL A: CROSSTUBE CUFF

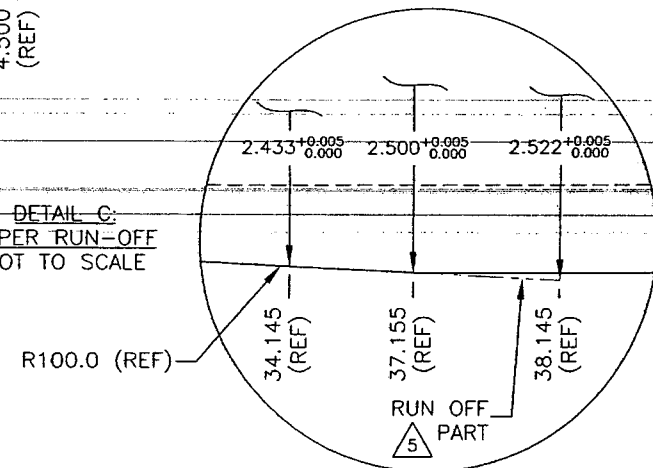


05.07.26 #  
**UNDER REVIEW**  
~~06.07.20 PH~~  
re-run detail r  
PH OK  
06.11.21




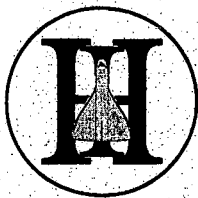
DETAIL B: CUFF  
TRANSITION  
SCALE 4:1

## DETAIL C: TAPER RUN-OFF NOT TO SCALE



NO. 24632  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
INCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN PH	DRAWN BY PH	 DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA	REV. B SHEET 3 OF 3 SCALE 1:1
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		DATE 05.07.26	TITLE CROSSTUBE ASS'Y (206L HIGH AFT)		



# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 35754

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

### INSPECTION REQUIREMENTS

Carry out FPI of (8) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (6) P/N D206-667-203 S/N's B28979, B29633, B29634, B29635, B28977 and B29632.  
Qty (1) P/N D206-667-103 S/N B29627.  
Qty (1) P/N D206-667-201 S/N B29094.



RADIOGRAPHY



ULTRASONIC



PENETRANT



MAGNETIC PARTICLE



EDDY CURRENT

### INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (8) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)  
Ardrox 970P25E Batch #04B503.

(8) cross tubes inspected. (5) PASSED / (3) FAILED.

Details: Failed S/N's B28979, B29634 and B29635.

- tubes are marked at locations requiring rework.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

DATE February 13, 2007

INSPECTION  
STAMP(S)

### CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

PO 00003046

ADDRESS:

CONTACT NAME: Linda Lacelle

LABOUR

@

\$

MATERIALS

@

TRAVEL EXPENSES

@

GST

HOTEL EXPENSES

@

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT